

Work Order ID: 83647

April 13 12 10:07:49 AM

\*83647\*

Page 1

Item ID: D350-636-011\*

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube LH

Start Date: 23/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/23

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

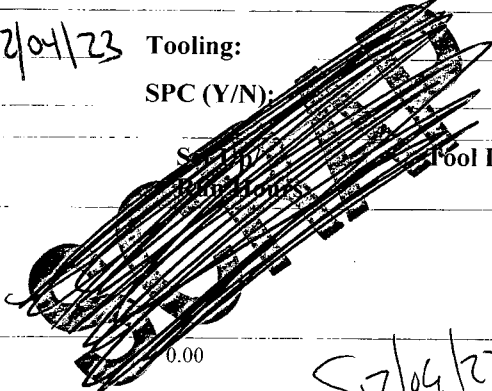
Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

0.00

0.00

*Siz 104/23*



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83647****\*83647\***

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April-23-12 10:07:49 AM

Item ID: D350-636-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 23/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 <b>*110*</b> Skidtubes Skidtubes	Skidtubes	0.00							
	<b>Memo</b>	0.00							
	1- Pick D2600-3 Bent ✓								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750 ✓								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr. ✓								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting ✓								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning. ✓								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B) ✓								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE*** ✓								
	8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side) ✓								
	9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". ✓								
	10- Open up holes of Detail A to 0.297" (total of 2 holes per side) ✓								

*9/11/04-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube LH

Stop \*NS2\*

Start Date: 23/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004

A/R Aluminum Rod batch: *M120H M120854 BE 12/04/26*

12-Grind welds flush as per Dwg D2750, *MTD 12-04-26*

120

QC10- Inspect visual per QSI004- ground welds 0.00

\*120\*

QC

Memo

0.00

*Sizbuzc*

Quality Control

130

QC5- Inspect part completeness to step on W/O 0.00

\*130\*

QC

Memo

0.00

*Sizbuzc*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 23/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

7/6 12-4-27

150

QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

Memo

0.00

Quality Control

12-5-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 23/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

**\*160\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes.

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 12/12/1

exp. date: 13-01-04

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R Aluminum Rod batch: M120854

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

*Handwritten notes and signatures:*  
A large bracket on the right side of the table spans from row 1 to row 10.  
Signature: [Signature] 1205-01  
3 BF 12/05/02  
u/cc 12-5-2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 83647

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April-23-12 10:07:49 AM

Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 23/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

OK/KC 12-5-2

8/12/05/02

8/12/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Work Order ID 83647

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Item ID: D350-636-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 23/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

MG 12-5-3

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

1:40  
320 °F  
2:10

ML 12/05/03

210

QC3- Inspect Part Finish

0.00

**\*210\***

QC

Quality Control

Memo

Inspect for foreign object per QSI 024

0.00

16H 12/05/03

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Work Order ID 83647

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Item ID: D350-636-011

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 23/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

**\*220\***

HandFinish

Hand Finishing

HandFinishing

Memo

1- Install inserts as per Dwg D2750

0.00

0.00

16H

DP

12/05/03

230

**\*230\***

HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

0.00

0.00

16H

DP

12/05/03

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 121221

EXP DATE: 13/01

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 110348

5-Coat all exposed fasteners with "LPS Procyon" batch: 114596

PHOTO

W/O: 83647		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-011 PAR #: Surp Fault Category: Skin tube NCR: Yes No DQA: Not Date: 12/06/28  
 Resolution: Surp Disposition: Re-work QA: N/C Closed:                      Date:                     

NCR: 12-1555		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/03	#1 230	Found During Assembly that D3488-041/42 Do not align with skin tube hole. R.C. tol on D3488-041/42 + Hummer Drill (Process)	CP 12.06.04	Drill out 24 x 5 aft most hole in SKIN to max tol Drill out 24 x 5 holes on D3488 to max tol	CP 12-6-6	CP 12.06.04	CP 12.06.04	CP 12/06/03
			CP 12.06.04	touch up hole with 19/64" dia As per 032005 + Re Assembly.	CP 12/06/20	CP 12.06.04	CP 12.06.04	CP 12/06/03
				Holes were Drilled too large Scrap + Destroy As per D.S. Recommendation Replace D3488-041 383407	CP 12/06/20			

NOTE: Date &amp; initial all entries



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Item ID: D350-636-011

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 23/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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240 QC5- Inspect part completeness to step on W/O 0.00

**\*240\***

QC Memo 0.00

Quality Control

1.4/14 PD 12-06-22

250 Pick Kit 0.00

**\*250\***

Packaging Memo 0.00

Packaging

9/2/25 C

260 QC4- 100% Inspect kits for completeness 0.00

**\*260\***

QC Memo 0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

8/2/06/27

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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## Quality Control

mf  
12-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

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\*83647\*

Parent Item: D350-636-011

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Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-23 As per Rev D JLM  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC  
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec  
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010  
 DD verf:EC IPP Rev:P 10.06.22 revise  
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH  
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3492-1		Manufactured	No			230	Each	221.0000	8	8			
*D3492-1*									**	8	(DP)	12/05/03	
Plug													

Location	Loc Qty	Loc Code
----------	---------	----------

FP002	14	
69531	8	
74444	2	
76235	4	
FP-A	207	
81963	7	
83098 ✓	200	

D3492-3		Manufactured	No			230	Each	189.0000	8	8			
*D3492-3*									**	8	(DP)	12/05/03	
Plug													

Location	Loc Qty	Loc Code
----------	---------	----------

FP-A	189	
81967	5	
83099 ✓	184	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*83647\*

\*D350-636-011\*

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

247.0000

8

8

\*NAS1611-010\*

O-RING

\*\*

8

28 12/05/03

## Location

## Loc Qty

## Loc Code

FP001

247

110915

14

117460

8

118077

1

118612

3

119438

47

120986

12

121166

12

121259

50

121415

100

NAS1149D0863J

Purchased

No

250

Each

179.0000

2

2

\*NAS1149D0863.I\*

WASHER

\*\*

## Location

## Loc Qty

## Loc Code

ST298

179

118078

34

119307

45

120308

100

D2744

Manufactured

No

110

Each

30.0000

1

1

\*D2744\*

Cap

\*\*

120308

BE 12/04/26

## Location

## Loc Qty

## Loc Code

LG002

30

62715

1

70881

1

78900

28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 83647

\*83647\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

30.0000

1

1

\*D2600-3-BENT\*

Extrusion Bent

\*\*

12-04-25

## Location

## Loc Qty

## Loc Code

LG

30

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

82347

3

83305

12

D2743

Manufactured No

160

Each

233.0000

8

8

\*D2743\*

Crossbolt Spacer

\*\*

BE 12-05-02

## Location

## Loc Qty

## Loc Code

LG

-51

81965

159

LG001

284

67766

4

68251

3

73403

64

74445

1

79517

2

D2739

Manufactured No

160

Each

3.0000

1

\*D2739\*

350 I Beam

\*\*

12-05-01

## Location

## Loc Qty

## Loc Code

LG

3

72155

1

81508

1

82124

1

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 83647

\*83647\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-3

Manufactured No

160

Each

46.0000

4

4

\*D3490-3\*

Cross Bolt Spacer

\*\*

Location

Loc Qty

Loc Code

LG

44

82016

44

LG001

2

78800

2

D3490-1

Manufactured No

160

Each

64.0000

4

4

\*D3490-1\*

Cross Bolt Spacer

\*\*

Location

Loc Qty

Loc Code

LG

55

81976

55

LG001

9

62450

2

74875

4

77042

3

ALS4-1032-225

Purchased No

220

Each

1,850.000

38

38

\*ALS4-1032-225\*

Insert

\*\*

Location

Loc Qty

Loc Code

ST281

1827

108696

146

110768

62

118386

55

118966

68

121269✓

1496

ST282

23

120410

10

120451

13

*A*

*BE 12/05/02*  
*B 83313 \*4*

*BE 12/05/02*  
*B 83269 \*3*

*/*

*38 (28) 12/05/03*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 5

Work Order ID: 83647

\*83647\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230 Each

17.0000 1 1

\*D3793-3\*

Wearshoe

\*\*

1 (DP) 12/05/03

## Location

## Loc Qty

## Loc Code

FP001

17

80434

6

82166 ✓

11

AN8C35A

Purchased No

230 Each

90.0000 1 1

\*AN8C35A\*

BOLT

\*\*

1 (DP) 12/05/03

## Location

## Loc Qty

## Loc Code

FP002

89

115960

1

118286 ✓

38

121275

50

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured No

230 Each

13.0000 1 1

\*D3793-1\*

Wearshoe

\*\*

1 (DP) 12/05/03

## Location

## Loc Qty

## Loc Code

FP001

13

82171 ✓

13

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 6

Work Order ID: 83647

**\*83647\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

3.0000

1

1

**\*D3488-041\***

Blade Fitting Assembly, LH

\*\*

1 (2P) 12/05/03

Location

Loc Qty

Loc Code

FP002

82271 ✓

3

61689

1

75056

1

77021

1

83407 ✓

230

Each

10.0000

1

1

\*\*

1 (2P) 12/05/03

D3794-3

Manufactured No

**\*D3794-3\***

Gasket

Location

Loc Qty

Loc Code

FP002

83396 ✓

10

74530

2

80436

8

230

Each

168.0000

4

4

\*\*

4 (2P) 12/05/03

AN6C44A

Purchased No

**\*AN6C44A\***

BOLT

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

166

120143

5

121013

11

121167 ✓

100

121440

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 83647

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

\*83647\*

\*D350-636-011\*

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

110.0000

1

1

\*MS21083C8\*

NUT

\*\*

1 (2P) 12/05/03

Location

Loc Qty

Loc Code

304

100

121185 ✓

50

121349

50

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

5

121011

5

D3536-25

Manufactured

No

230

Each

9.0000

1

1

\*D3536-25\*

Gasket

\*\*

1 (2P) 12/05/03

Location

Loc Qty

Loc Code

FP

83391 ✓

9

81342

9

D3631-1

Manufactured

No

230

Each

115.0000

8

8

\*D3631-1\*

Washer

\*\*

8 (2P) 12/05/03

Location

Loc Qty

Loc Code

FG

100

81874 ✓

100

ST072

15

68062

2

75548

13

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83647

\*83647\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

12.0000

1

1

\*D3791-1\*

Wearplate

\*\*

1 ~~28~~ 12/05/03

Location

Loc Qty

Loc Code

FP002

83392 ✓

12

62239

2

82168

10

230

Each

0.0000

38

38

AN960C10L

\* NAS1149C0332 ✓ Purchased

No

\*AN960C10I \*

washer

D2745

Manufactured No

230

Each

36.0000

8

8

\*D2745\*

Bushing

\*\*

38 ~~28~~ 12/05/03

\*\*

8 ~~28~~ 12/05/03

Location

Loc Qty

Loc Code

FP

6

79518

6

FP001

30

69529

1

76142

1

81964 ✓

28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83647

\*83647\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,642.000

34

34

\*AN3C5A\*

Bolt

\*\*

34

(2P)

12/05/03



Location

Loc Qty

Loc Code

FP001

121068 ✓

7

27

115835

7

ST350

1635

~~24~~

116419

28

117343

13

117764

7

117872

2

119749

23

120423

62

1210168

500

121255

500

121444 ✓

500

7

D3537-1

Manufactured

No

230

Each

17.0000

3

3

\*D3537-1\*

Wearpad

\*\*

3

(2P)

12/05/03

Location

Loc Qty

Loc Code

FG

81959 ✓

10

79833

10

FP002

7

69817

5

73716

2

NAS1149C0832R

Purchased

No

230

Each

279.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

1

(2P)

12/05/03

Location

Loc Qty

Loc Code

ST297

279

114915 ✓

279

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83647

\*83647\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

425.0000

4

4

**\*AN3C6A\***

BOLT

\*\*

4

*DP 12/05/03*

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

424

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693 ✓

332

NAS1611-013

Purchased

No

230

Each

154.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

8

*DP 12/05/03*

Location

Loc Qty

Loc Code

FP001

154

*12584 ✓*

116582

5

117291

2

117887

53

119623

36

121166

8

121259

50

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 83647

\*83647\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

26.0000

1

1

\*D3535-25\*

Wearshoe

\*\*

1 (DP) 12/05/03

## Location

## Loc Qty

## Loc Code

FP001

26

62233

1

81357

8

82156 ✓

17

D3794-1

Manufactured No

230

Each

26.0000

1

1

\*D3794-1\*

Gasket

\*\*

1 (DP) 12/05/03

## Location

## Loc Qty

## Loc Code

FP

23

82167 ✓

23

FP002

3

75042

2

80435

1

MS21043-6

Purchased No

230

Each

710.0000

4

4

\*MS21043-6\*

NUT

\*\*

4 (DP) 12/05/03

## Location

## Loc Qty

## Loc Code

FG

20

103693

20

ST301

690

117887

6

118384 ✓

184

120308

500

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 12

Work Order ID: 83647

\*83647\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

55.0000

2

2

\*D3493-1\*

Washer

\*\*

83647

## Location

## Loc Qty

## Loc Code

ST050

55

70697

2

77573

1

78835

11

82023

41

Purchased

No

250

Each

110.0000

2

2

MS21083C8

\*MS21083C8\*

NUT

\*\*

4/26/12

## Location

## Loc Qty

## Loc Code

304

100

121185

50

121349

50

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

5

121011

5

M121349

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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\*83647\*

\*D350-636-011\*

Work Order ID: 83647

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

89.0000

2

2

\*\*

\*AN8C21A\*

BOLT

Location

Loc Qty

Loc Code

ST343

89

118758

3

121067

16

121167

20

121275

50

NAS1515H3L

Purchased

No

230

Each

134.0000

4

4

\*\*

\*NAS1515H3I \*

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

94

118686

3

119438

1

120360

40

121243 ✓

50

D2741

Manufactured

No

250

Each

41.0000

1

1

\*\*

\*D2741\*

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-10

ST466

51

71856

1

76984

2

79516

38

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 83647

\*83647\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250

Each

29.0000

2

2

\*D3532-1\*

\*\*

Spacer

83647 12/4/2012 ①

Location

Loc Qty

Loc Code

ST053

29

78839

5

82041

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/2-3/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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12/04/23

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F	INCORPORATE DSI 9413. QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS. ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	REV. F
D2750	SHEET 1 OF 11
TITLE	SCALE
350 SKIDTUBE ASSEMBLY	NTS
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**Dart Aerospace Ltd**

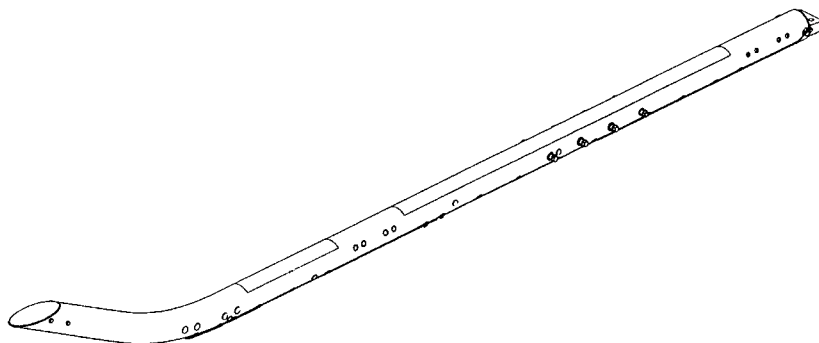
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

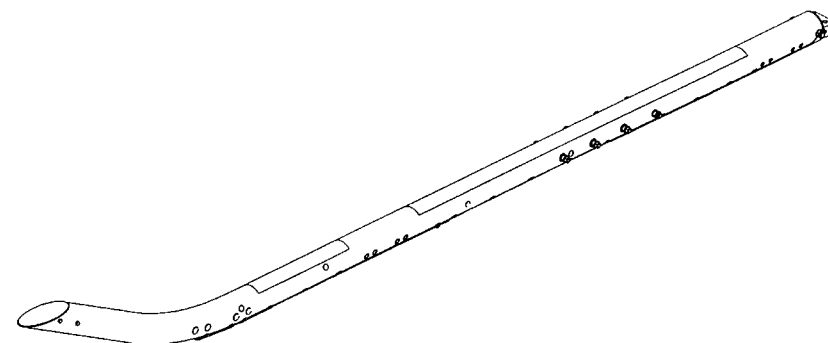
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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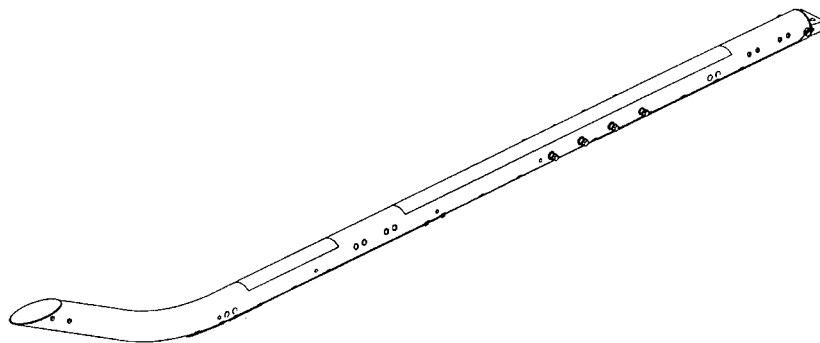
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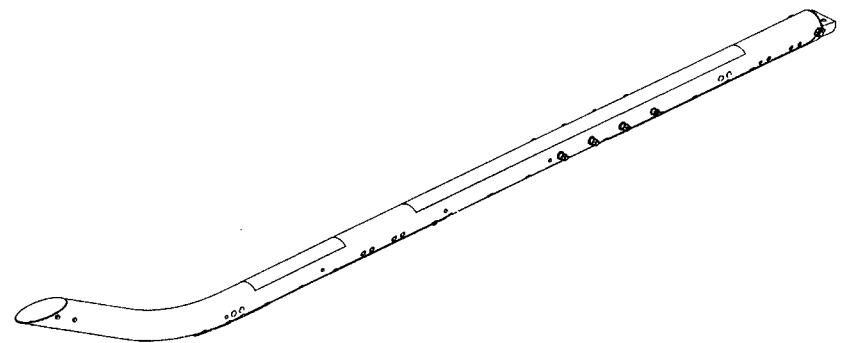
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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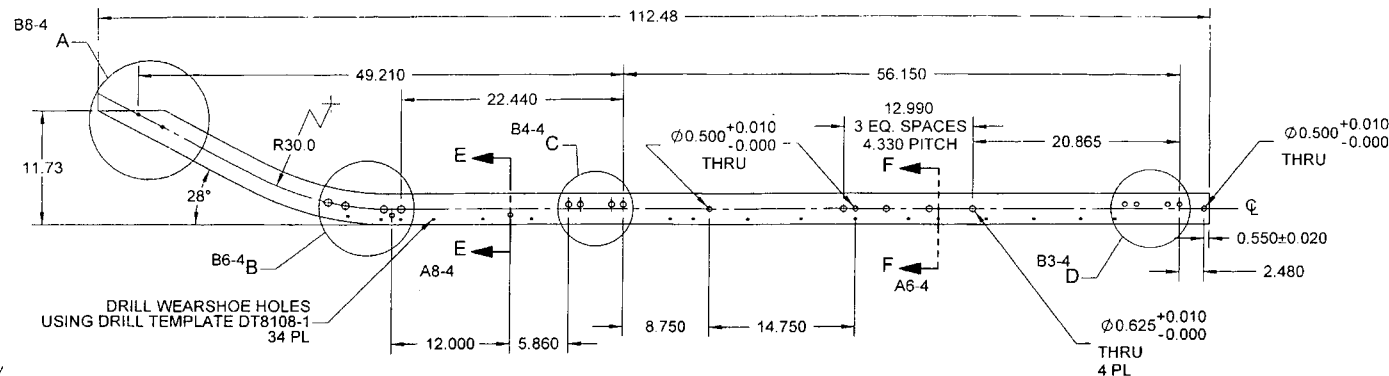
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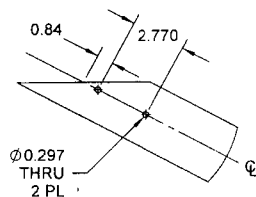
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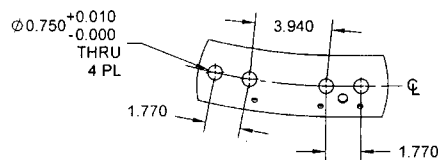
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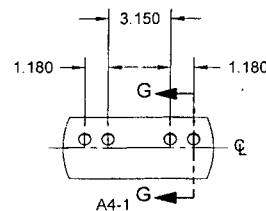
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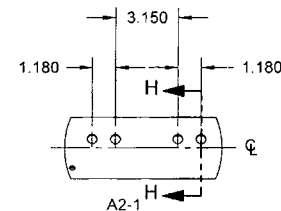
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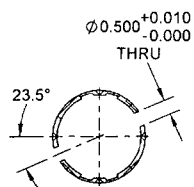
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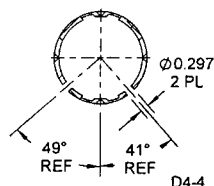
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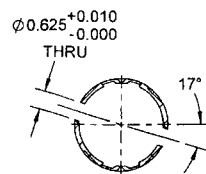
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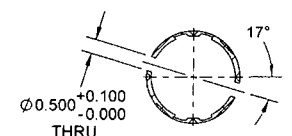
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN	IP
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DE APPR.	
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**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F  
SHEET 4 OF 11  
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

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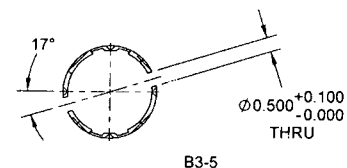
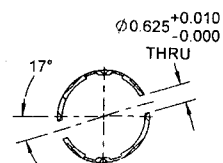
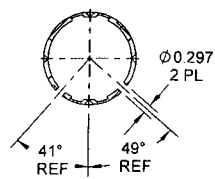
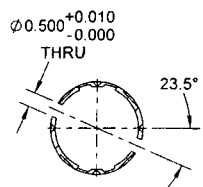
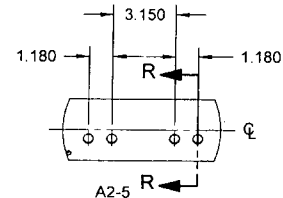
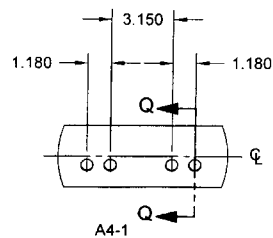
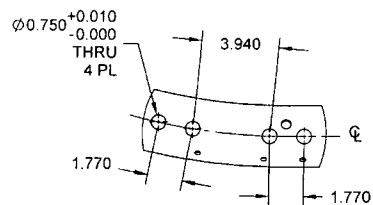
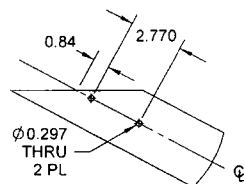
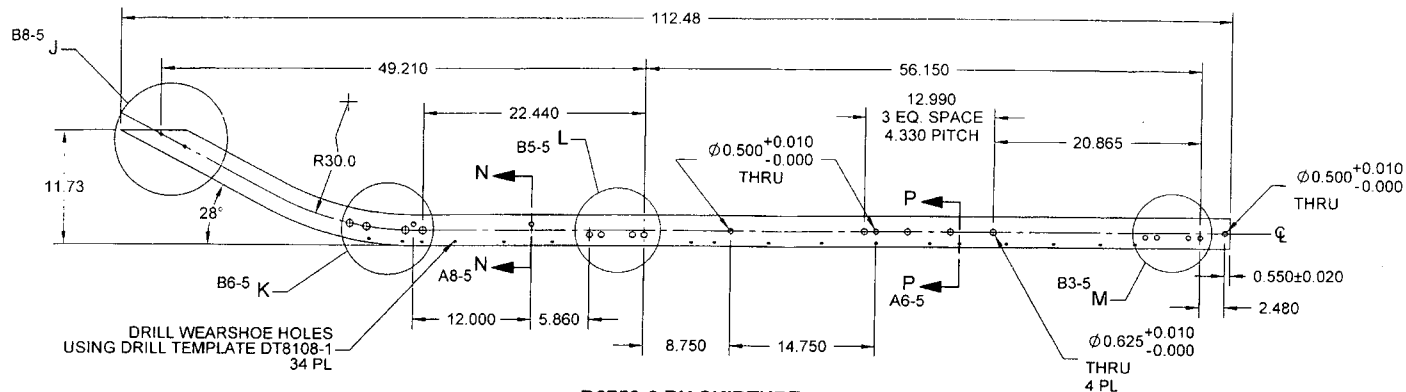
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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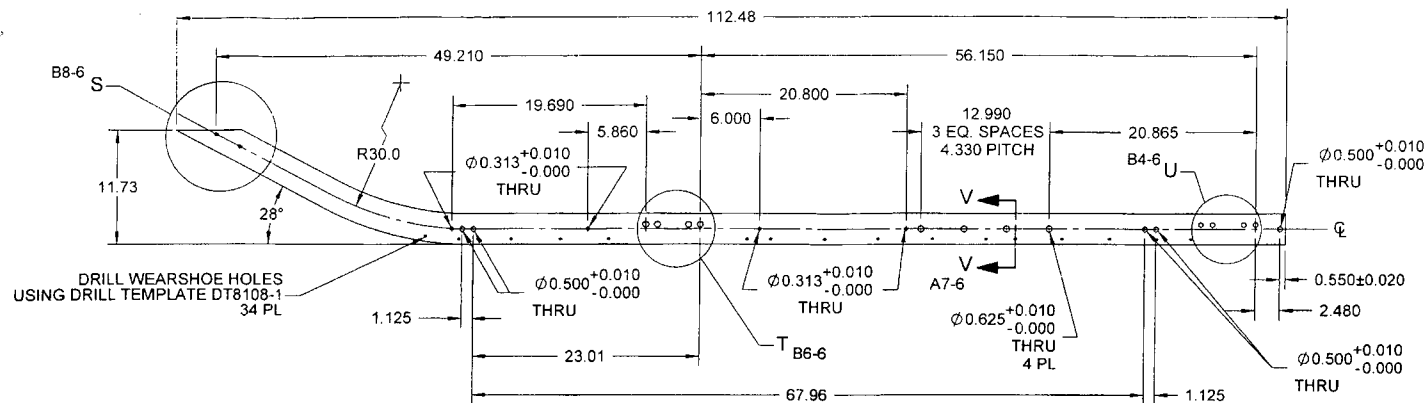
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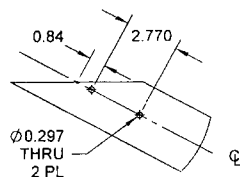
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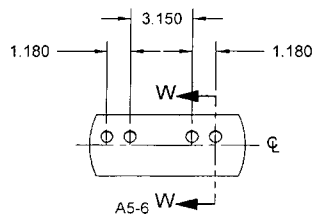
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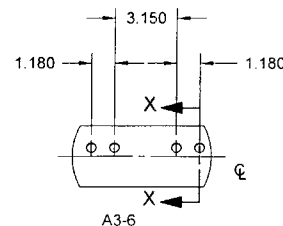
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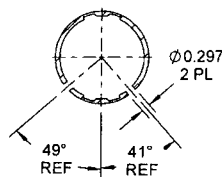
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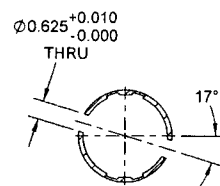
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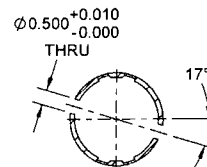
D3-6



C4-6



B6-6



B4-6

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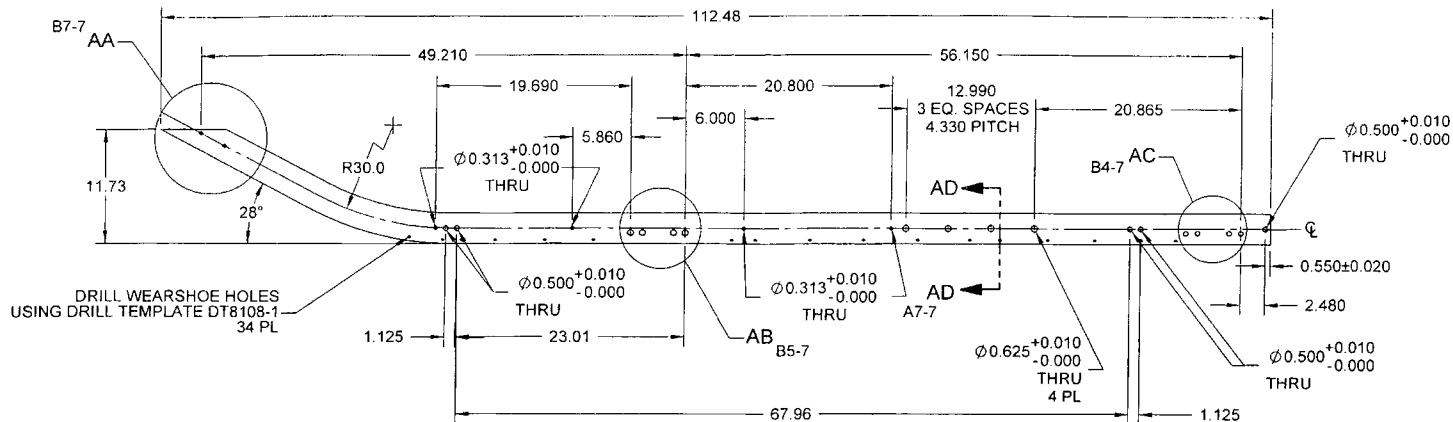
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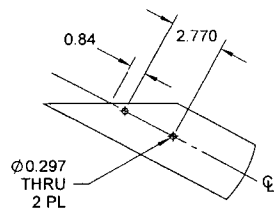
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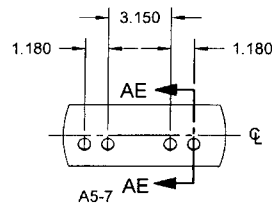
**NOTE:** Date & initial all entries



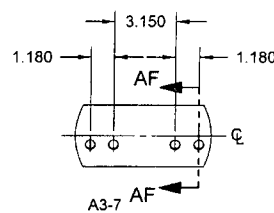
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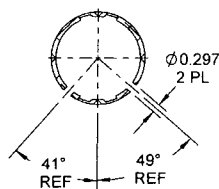
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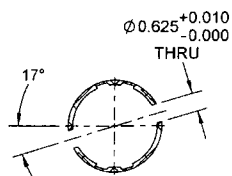
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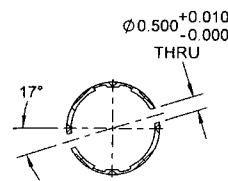
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SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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08-09-2010

DESIGN	PAH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PAH	PORT HADLOCK, WA	
CHECKED	PAH	DRAWING NO.	REV. F
MFG. APPR.	PAH	D2750	SHEET 7 OF 11
APPROVED	PAH	TITLE	SCALE
DE APPR.	PAH	<b>350 SKIDTUBE ASSEMBLY</b>	
DATE	08.07.16	NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

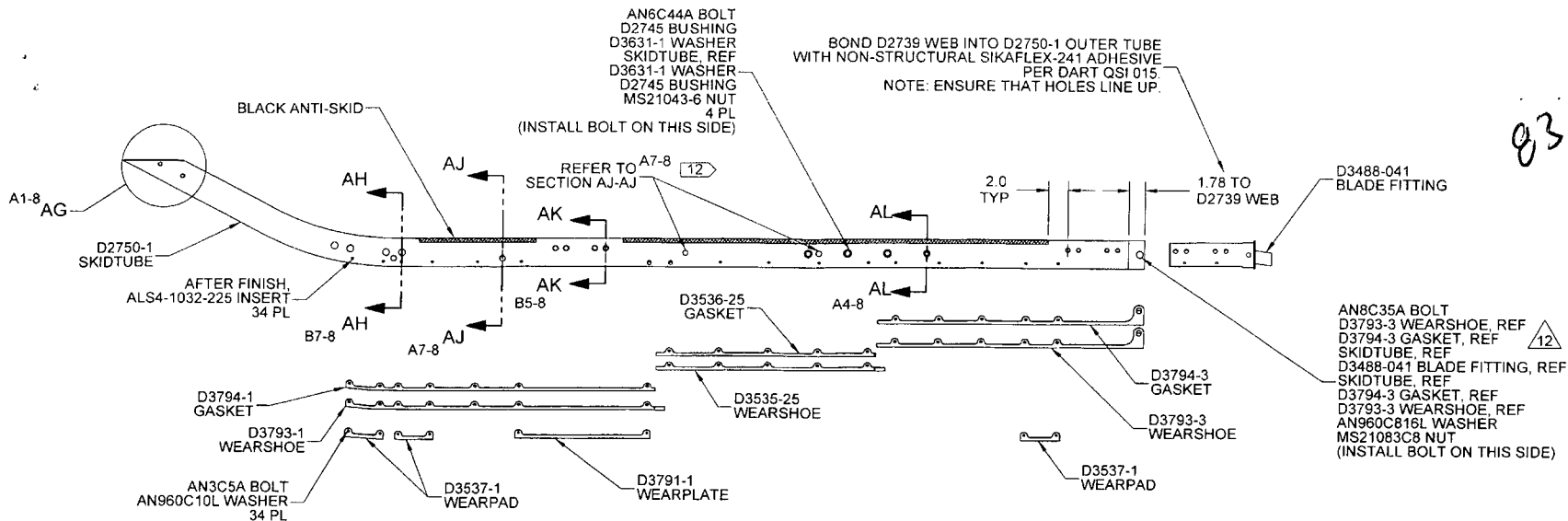
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

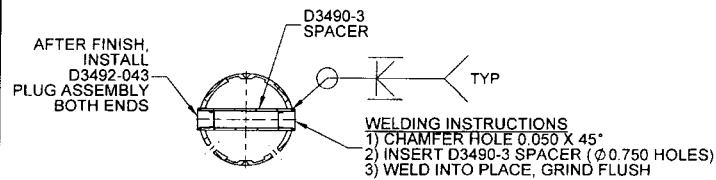
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

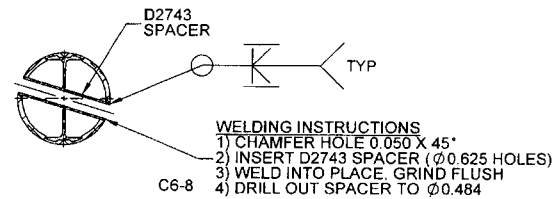
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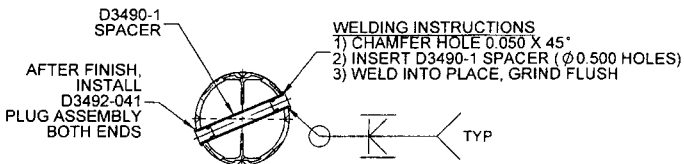
**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



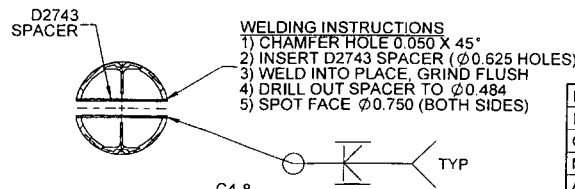
**SECTION AH-AH**  
SCALE 3X, 4 PL



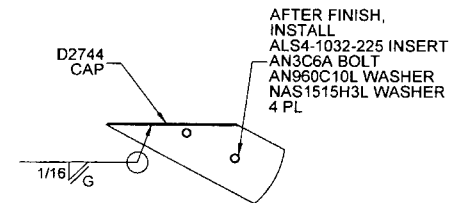
**SECTION AK-AK**  
SCALE 3X, 4 PL



**SECTION AJ-AJ**  
SCALE 3X, 4 PL



**SECTION AL-AL**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AG**  
SCALE 2X

**RELEASED**  
08.07.16

DESIGN	REV. F	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	REV. F	DRAWING NO.	REV. F
CHECKED	REV. F	D2750	SHEET 8 OF 11
MFG. APPR.	REV. F	TITLE	SCALE
APPROVED	REV. F	350 SKIDTUBE ASSEMBLY	NTS
DE APPR.	REV. F	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	08.07.16		



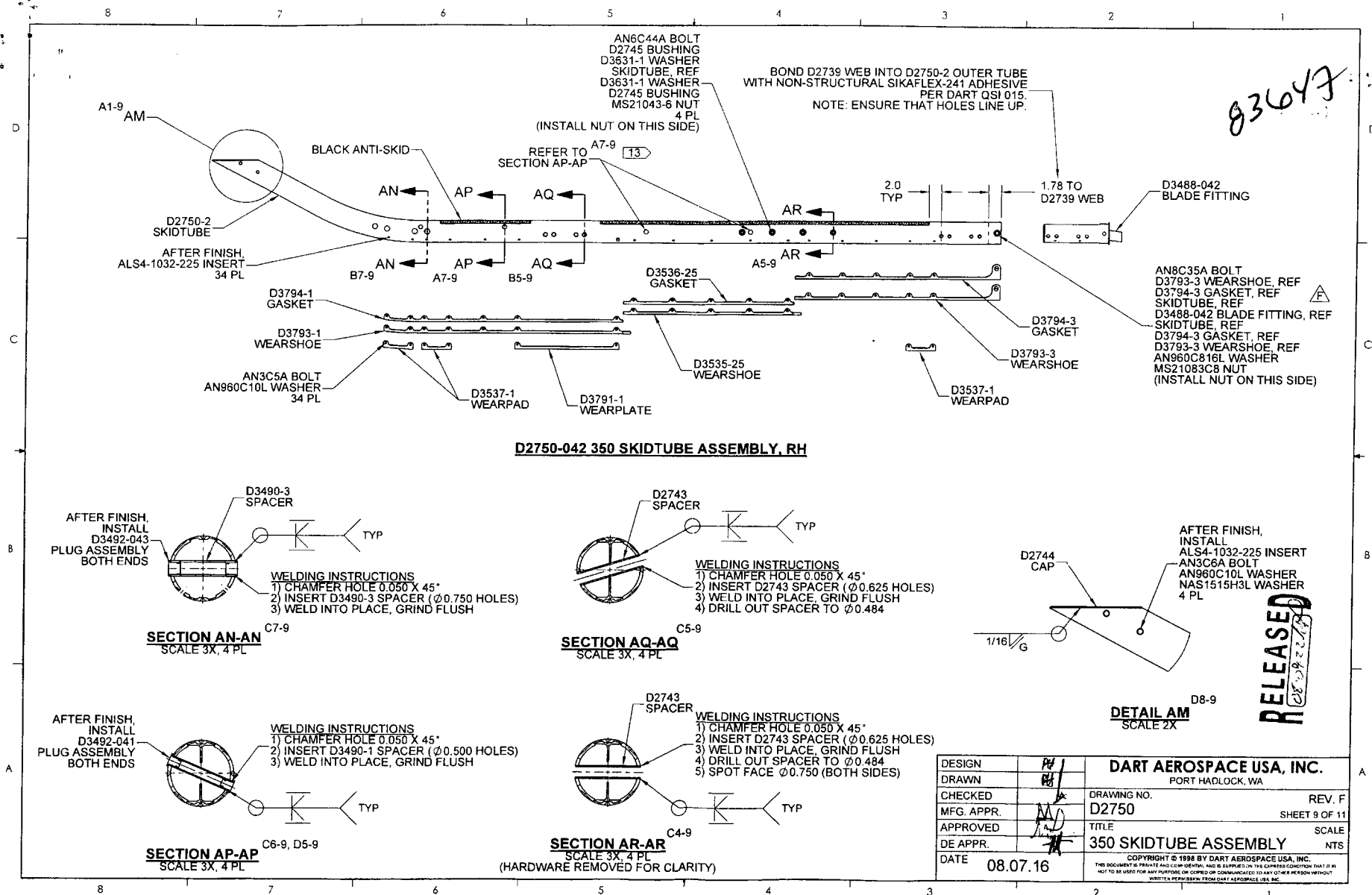
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

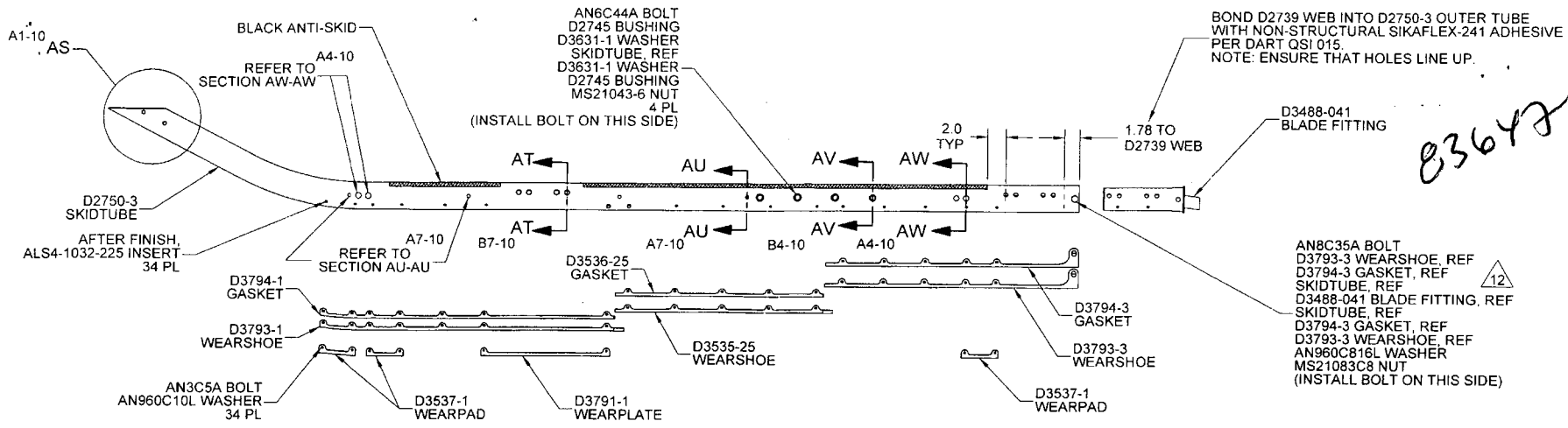
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

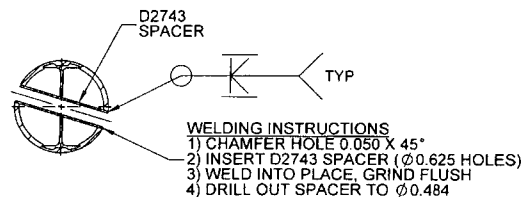
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

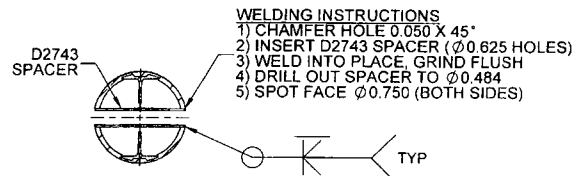
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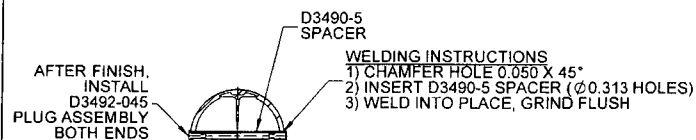
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



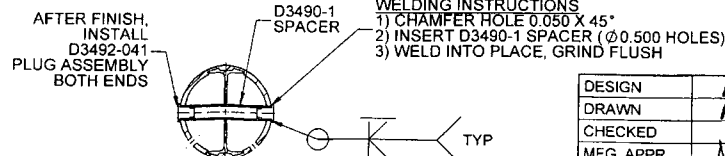
**SECTION AT-AT**  
SCALE 3X, 4 PL



**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION AU-AU**  
SCALE 3X, 4 PL



**SECTION AW-AW**  
SCALE 3X, 4 PL



**DETAIL AS**  
SCALE 2X

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.	

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RELEASED  
R 025-08-22-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

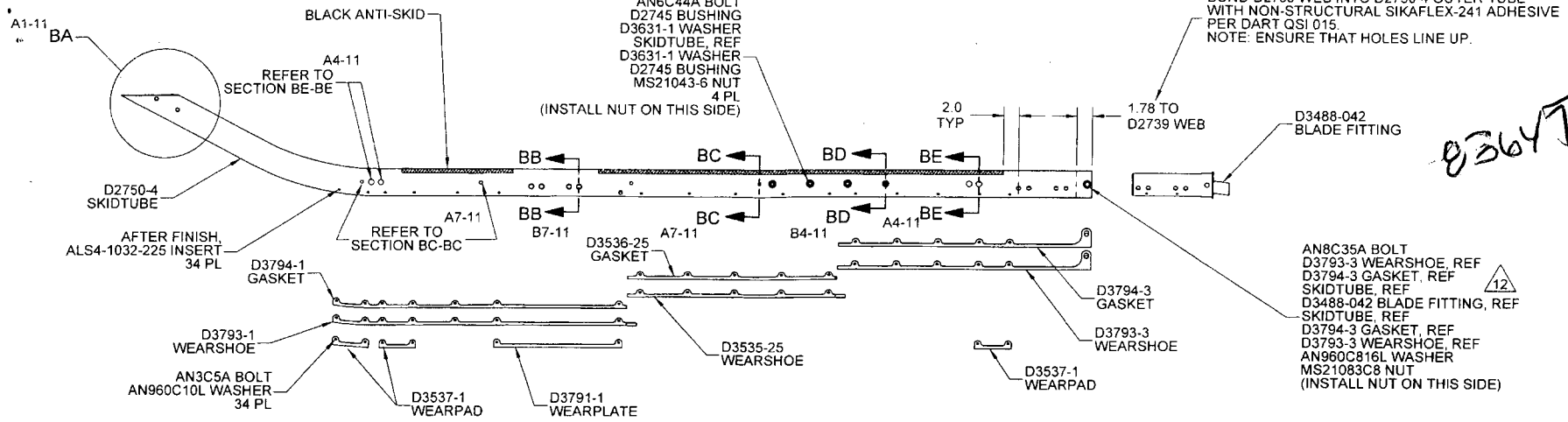
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

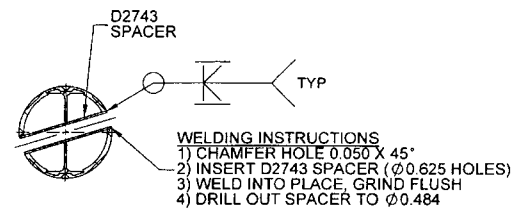
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

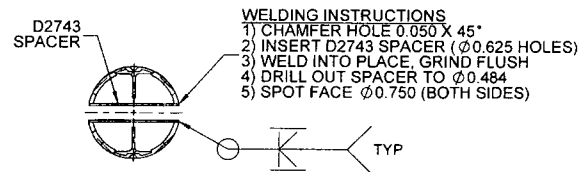
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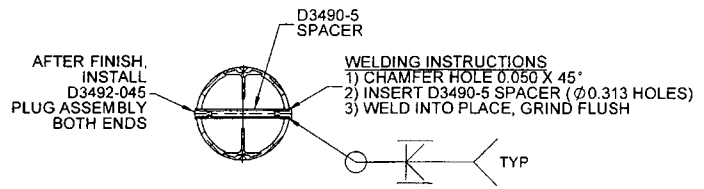
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



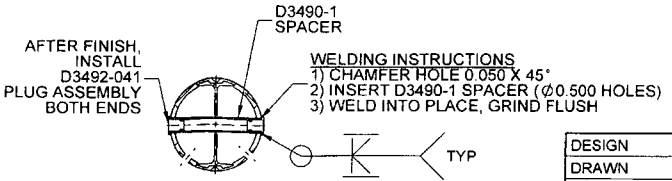
**SECTION BB-BB**  
SCALE 3X, 4 PL



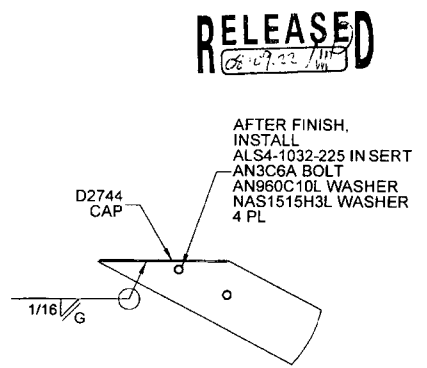
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

DESIGN	REV. 1	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	REV. 1	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 293

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 82796  
Part number: 1350-636-014  
Description: Skid tube  
Welding Process: Tig[ ☒ ] Mig[ ☐ ]  
Base material: Alum  
Current: AC[ ☒ ] DC[ ☐ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[ ☒ ] fail[ ☐ ]  
Penetration: pass[ ☒ ] fail[ ☐ ]

UNACCEPTABLE

Cracks: pass[ ☒ ] fail[ ☐ ]  
Undercut: pass[ ☒ ] fail[ ☐ ]  
Pin holes: pass[ ☒ ] fail[ ☐ ]  
Overlap (cold lap): pass[ ☒ ] fail[ ☐ ]  
Porosity (surface): pass[ ☒ ] fail[ ☐ ]  
Coloration: pass[ ☒ ] fail[ ☐ ]

Qualifier David Meunier Date of Test Coupon 12-05-01  
Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld